

Split  
Work Order ID 62494 -1



Page 1

Thursday, September 30, 2010 2:31:46 PM

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3909

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/30/10 12/14 ①

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
Trim rivet to 1.185" long

9/30/10 12/14 ①

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/15

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62494**

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Page 2

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Start Date: 9/30/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

0.00

Packaging

*6/12/10 (1)*

140



QC

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*10/12/10**MF 10-12-10*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, September 30, 2010 2:31:51 PM

Page 1

Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	31.0000	1	6		9/30/11/29	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST020				31					
				59960				6					
				61382				25					
* D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	15.0000	2	12		9/30/11/29	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST095				15					
				57824				8					
				59155				7					
* D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	13.0000	1	6		9/30/11/29	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST095				13					
				59209				1					
				59442				12					
- D3909-5  Eyebolt Stud		Manufactured	No			100	Each	1.0000	1	6		9/30/11/29	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST095				1					
				58240				1					

B62492 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, September 30, 2010 2:31:51 PM

Page 2

Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

 D3910-1  
  
Crosstube Lug

Manufactured No 100 Each 9.0000 2 12

Location	Loc Qty	Loc Code
st507	9	
59349	8	
59708	1	



*EP 10/11/29*  
*B62009 (4x)*

D3917-1  
  
Washer

Manufactured No 100 Each 72.0000 2 12

Location	Loc Qty	Loc Code
ST065	40	
57821	40	
ST096	32	
60170	32	



*EP 10/11/29*  
*B62944 (6x)*  
*B64106 (1x)*

AN3C12A  
  
Bolts

Purchased No 100 Each 62.0000 4 24

Location	Loc Qty	Loc Code
ST351	62	
112314	8	
114761	11	
115392	23	
115594	20	



*EP 10/11/29*  
*M116022 (24x)*

AN3C13  
  
Bolt

Purchased No 100 Each 70.0000 1 6

Location	Loc Qty	Loc Code
ST351	70	
114304	26	
114714	44	



*EP 10/11/29*  
*6*

Thursday, September 30, 2010 2:31:51 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, September 30, 2010 2:31:51 PM

Page 3

Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

MS17984-C413

Purchased

No

100

Each

18.0000

1

6



PIN, QUICK RELEASE

## Location

## Loc Qty

## Loc Code

ST297

4

114340

4

ST314

14

114523

1

114886

13



EP 9/30/11/29  
M116081 (5x)

M116304 (12)

MS20615-4M18

Purchased

No

100

Each

266.0000

3

18



RIVET

## Location

## Loc Qty

## Loc Code

ST323

266

114808

96

115054

170



EP 9/30/11/29  
M115037 (18x)

AN310C3

Purchased

No

100

Each

70.0000

1

6



Castellated Nut

## Location

## Loc Qty

## Loc Code

ST349

70

114304

20

114714

50



EP 9/30/11/29  
6

Thursday, September 30, 2010 2:31:51 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, September 30, 2010 2:31:51 PM

Page 4

Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

MS21043-3 Purchased

No

100

Each

2,599.000

4

24



Nut

## Location

## Loc Qty

## Loc Code

FG

76

103691

76

ST301

2523

111383

46

112314

2477

MS24665-151

Purchased

No

100

Each

617.0000

1

6



Cotter Pin

## Location

## Loc Qty

## Loc Code

ST309

617

17566

617

NAS1149C0332R

Purchased

No

100

Each

443.0000

8

48



Washer

## Location

## Loc Qty

## Loc Code

ST297

443

113524

10

113737

150

115000

125

115698

158

*EB10/11/29*

*24*  
*6*  
*EB10/11/29*

*6*  
*48*  
*EB10/11/29*

*M115832 (48x)*

Thursday, September 30, 2010 2:31:51 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, September 30, 2010 2:31:51 PM

Page 5

Work Order ID: 62494



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0363R

Purchased

No

100

Each

5,838.000

2

12



Washer



*g510/11/29*

Location

Loc Qty

Loc Code

ST297

5838

113524

188

113644

150

113889

500

114742

5000

*12*

Thursday, September 30, 2010 2:31:51 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

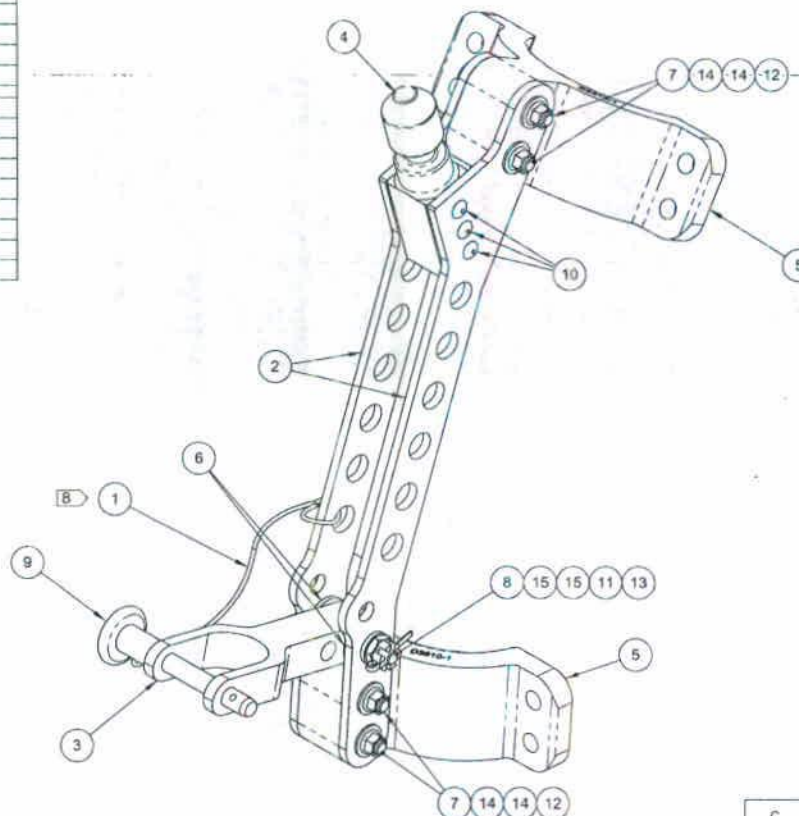
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



**D3909-041 FWD X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER

- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *02494*  
*B810-9-30*

**RELEASED**  
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5). 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BCM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED. SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00. 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3909</b> REV. C SHEET 1 OF 5 TITLE <b>FWD X-TUBE LUG ASSY</b> SCALE NTS COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.06.18		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



D3910-1  
X-TUBE LUG  
2 PL

D2690-6  
LANYARD

MS17984-C413  
PIP PIN

D3917-1  
WASHER

D3909-5  
EYEBOLT STUD

MS20615-4M20  
RIVET  
3 PL

D3909-1  
FWD X-TUBE LUG PLATE  
2 PL

D3909-3  
FWD LOWER ATTACH ARM

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043-3 NUT  
4 PL

AN3C13 BOLT  
NAS1149C0363R WASHER, 2X  
AN310C3 NUT - CASTELLATED  
MS24665-151 COTTER PIN

*w/o 62494*

**RELEASED**  
2010-08-04

**D3909-041 FWD X-TUBE LUG ASSY**

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. <b>D3909</b>	REV. C
MFG. APPR.	JPH	TITLE <b>FWD X-TUBE LUG ASSY</b>	SHEET 2 OF 5
APPROVED	JPH	SCALE	NTS
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.06.18	THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THE CONTENTS HEREIN IS TO BE REPRODUCED OR COPIED IN ANY MANNER OR FOR ANY PURPOSES WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

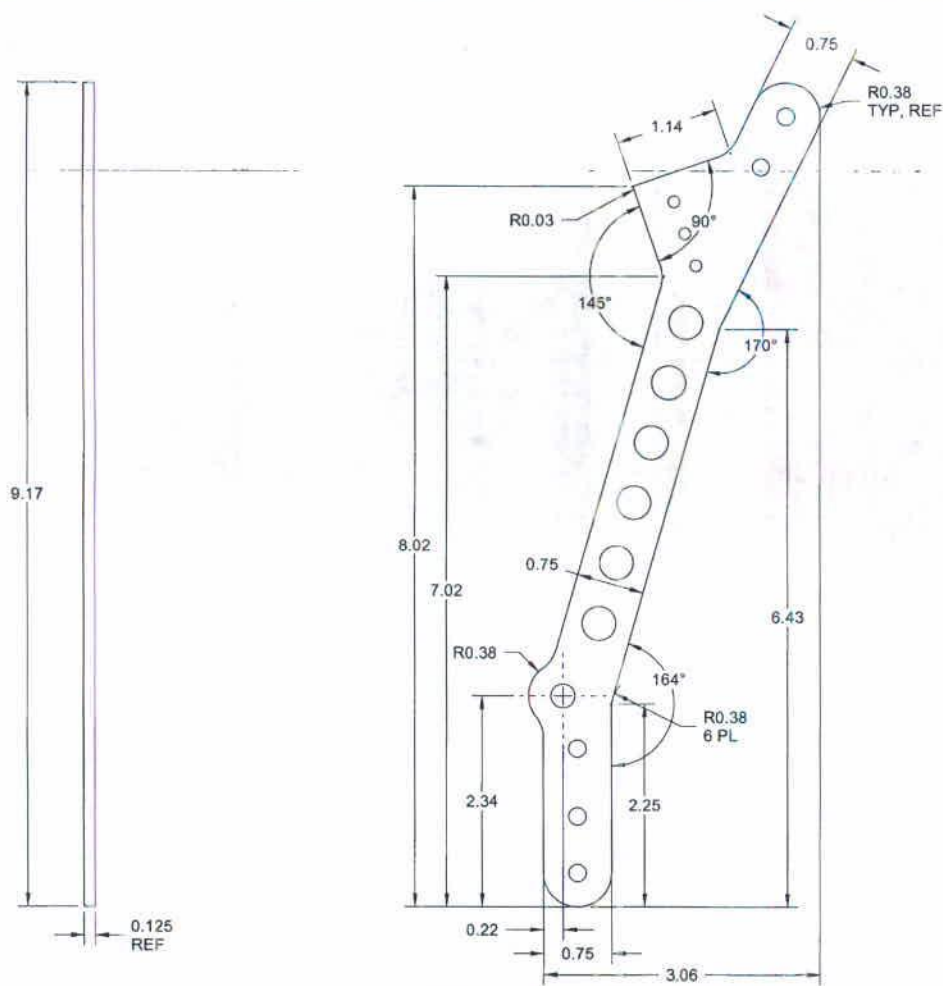
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

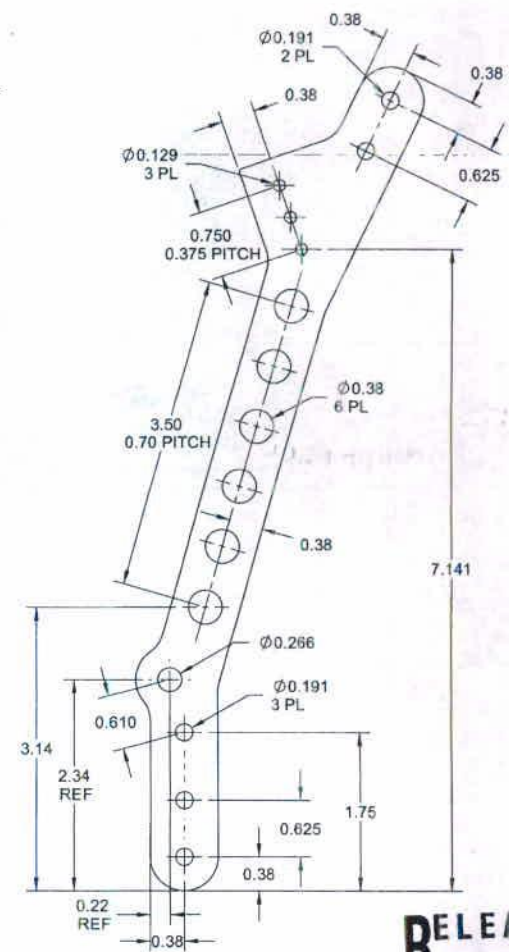
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**NOTE:** Date & initial all entries

Wto 62494



**D3909-1 FWD X-TUBE LUG PLATE**



(SUPPLEMENTAL VIEW)

**RELEASED**  
2010-08-04

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD.X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD.	
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W/O:		WORK ORDER CHANGES					
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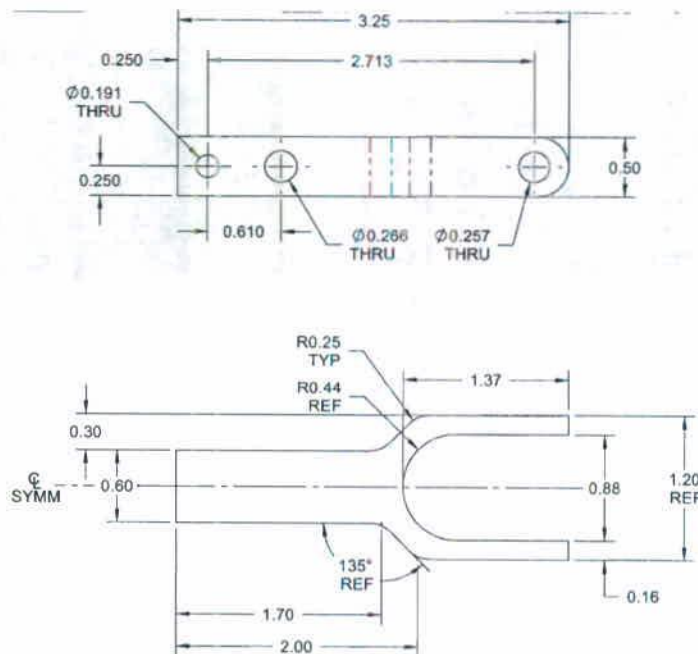
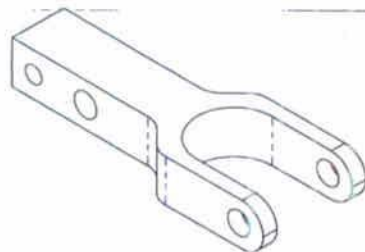
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries






**D3909-3 FWD LOWER ATTACH ARM**

*Wb 42494*

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

**RELEASED**  
2010-08-01  
*Wb*

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR. --		FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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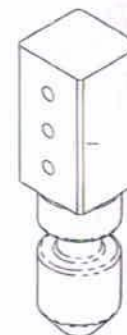
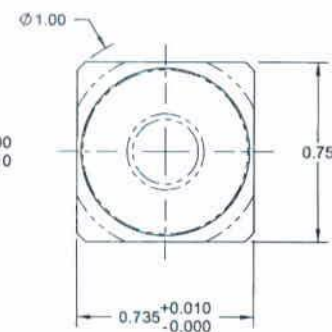
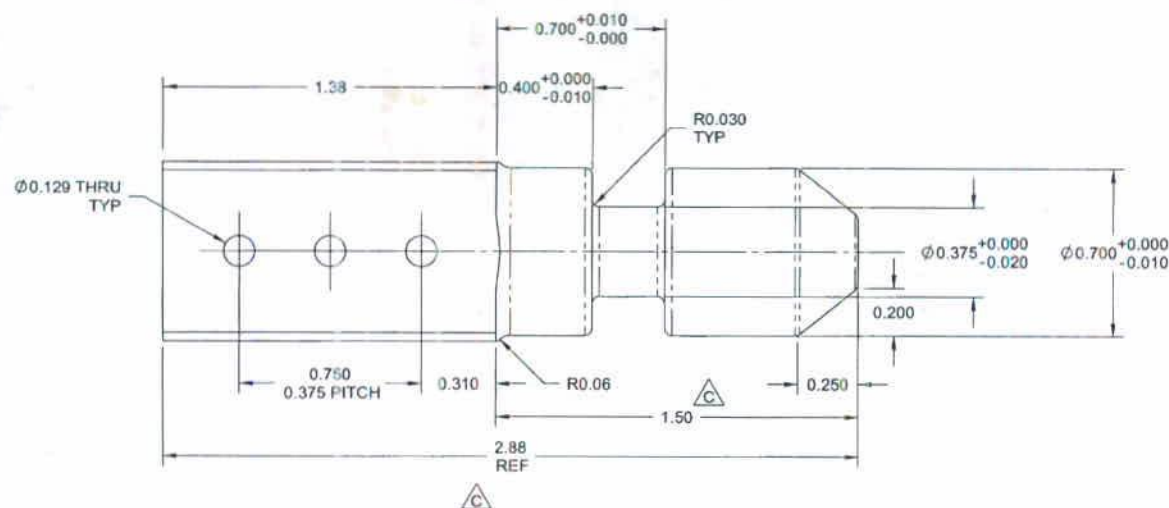
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



*w/0 42494*

**D3909-5 EYEBOLT STUD**

**RELEASED**  
2010-08-04

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries